

Please Next

Date: Tuesday, 02/12/2008 11:16:58 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG ASSEMBLY 206L/407 GHW LUG		
Job Number	: 43885			Part Number	: D2659		
Estimate Number	: 10318			Drawing Number	: D2659 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/12/2008 S.O. No. :			Drawing Revision	: A		
Prsh Rev.	: NC			Material	:		
First Issue	: / / Type : PURCHASED PARTS			Due Date	: 05/12/2008 Qty: 14 Um: Each		
Previous Run	: 34614						
Written By	:						
Checked & Approved By	: <u>JUL 08. 12.02</u>						
Comment	: Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	43885A	LUG
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*✓ 2 of these were
SS taken out
of system*

Comment: Sub-Component LUG

1 x D2657 Batch B34076A

EL 8-12-3 (X14) replace
DT8208

2.0	43885B	LUG BRACKET
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Comment: Sub-Component LUG BRACKET

1 x D2658 Batch 3X19607

11x B34076B

EL 8-12-3 (X14)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using location Jig DT8208

A/R Steel Rod M108350

EL 8-12-3 (X18)

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

Cd08-12-04 RE 08-12-04 (X12)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S08/12/08 (X12)

6.0	POWDER COATING	POWDER COATING
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M109152

(X12)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:15

M-1

08/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2659 PAR #: N/A Fault Category: Prod/ FAB. Large
 Resolution: Scrap Disposition: SCRAP NCR: Yes No DQA: ID Date: 08/12/02
 QA: N/C Closed: ID Date: 08/12/02

NCR: 43885		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				
8/12/02	# 30	After welding welder notices that the D2657 lug was not cleaned colour. He then realized that the D2657 was stainless steel not mild steel.	AS1412	SCRAP D3414-3 S.S lug. Qty (2) also SCRAP D2658 steel lug Bracket Qty (2) no replace.	EL 8-12-3	S 8/12/02	AS1412	S 08/12/02
		steel. R.C. 2 were wrong D3414-3 were mixed with D2657. Didn't notice till after welding. Lack of attention on	AS1412	- employee to check material before welding with magnetic to ensure no mix ups. - SS the work areas, and			AS1412	S 08/12/03
		The employee who placed the S.S lug in to the steel box. Not the employee affected on this wro.	AS1412	ensure parts are correctly identified & stocked.			AS1412	S 08/12/03

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 43885

Part Number: D2659

Job Number:



Seq. #: Machine Or Operation:

OF

Description :

OVEN TEMPERATURE:

400
11-45

FINISH TIME:

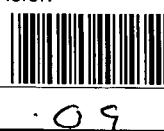
M-1 08/12/09

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gl



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-09

(12)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST U65

SS 08/12/11 (12)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 ff

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR 08-12-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

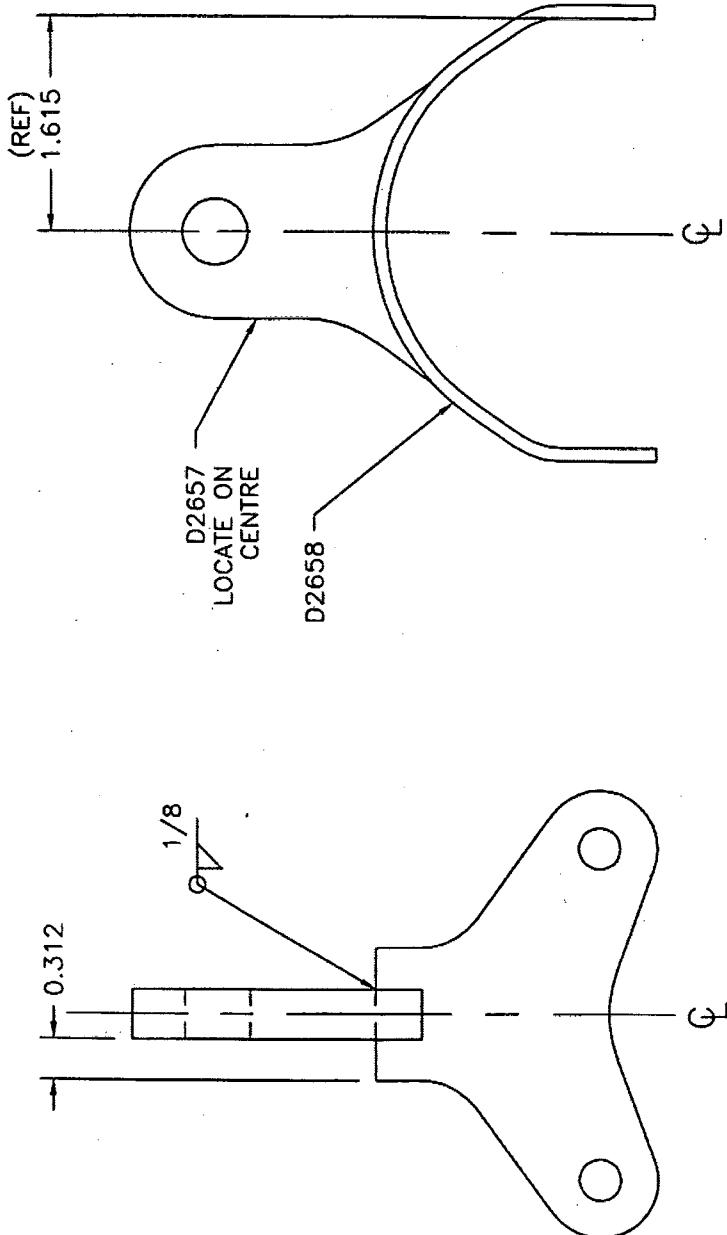
NOTE: Date & initial all entries

DART

©COPY
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO. D2659
DATE		REV. A SHEET 1 OF 1
97.11.03		TITLE LUG ASSEMBLY
A	97.11.03	SCALE NTS NEW ISSUE

RELEASED
97/11/06 PS



D2659 LUG ASSEMBLY

WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)

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RETURN TO
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WORK ORDER
NO. 13885